

Work Order ID 84828

84828

Page 1

May-24-12 7:54:53 AM

Item ID: D206-628-031

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/24

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

DAS 16
12/07/18 JB

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-031 CHG 003

for MLJ 12-7-18

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2 12/07/18 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16
12/07/18 JB

(2)
LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Heli-Access-Step LH

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP D206-628-031

Location: _____

PPP Rev: RE

12/17/19 (3)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/17/20

ME
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 84828

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Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step LH

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP RevE as per ecn 1118 08-02-05 DD verified by:EC IPP Rev:F
as per chg 003 DD 10.02.25 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No			110	Each	1,433.000	4	8	✓		

AN4-13A
Bolt

**

JB

Location	Loc Qty	Loc Code
ST357	1433	
119449	33	
120187	19	
120422	2	
120770	379	
121652	1000	

AN4-14A
AN4-14A
Bolt

Purchased No

110 Each 344.0000

**

121652
8 ✓

122141 JB 12/07/18

Location	Loc Qty	Loc Code
357	100	
121349	100	
ST357	244	
120187	13	
120769	1	
121068	17	
121444	100	
121708	113	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
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Picklist Print

May-24-12 7:54:57 AM

Page 2

Work Order ID: 84828

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Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step LH

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-15A Purchased No

110 Each

583.0000

4

8

AN4-15A

Bolt

**

122141 JB

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

383

118706

3

120422

80

121444

100

121541

200

AN960JD416 NAS1149D0463J Purchased No

110 Each

30.0000

12

24

AN960JD416

Washer

**

122441 JB

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

D2724-041 Manufactured No

110 Each

0.0000

0

2

D2724-041

206L Step Assembly

D2731-3 Manufactured No

110 Each

68.0000

4

8

D2731-3

Mounting Lug

**

JB

12/07/18

Location

Loc Qty

Loc Code

ST469

68

73417

68

73417

May-24-12 7:54:57 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

May-24-12 7:54:57 AM

Page 3

Work Order ID: 84828

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Parent Item: D206-628-031

D206-628-031

Parent Item Name: Heli-Access-Step LH

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

D2732-030

Manufactured No

110 Each

2.0000

8

16

**

83560 JB

D2732-030

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

2

76850

1

81499

1

76850

D3394-041

Manufactured No

110 Each

70.0000

8

**

JB

D3394-041

Lug Assembly

Location

Loc Qty

Loc Code

ST479

70

74505

30

82149

40

74505

MS21042L4

Purchased No

110 Each

4,300.000

24

**

JB 12/01/18

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

4300

119075

125

121011

918

121444

2957

121652

300

121444

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

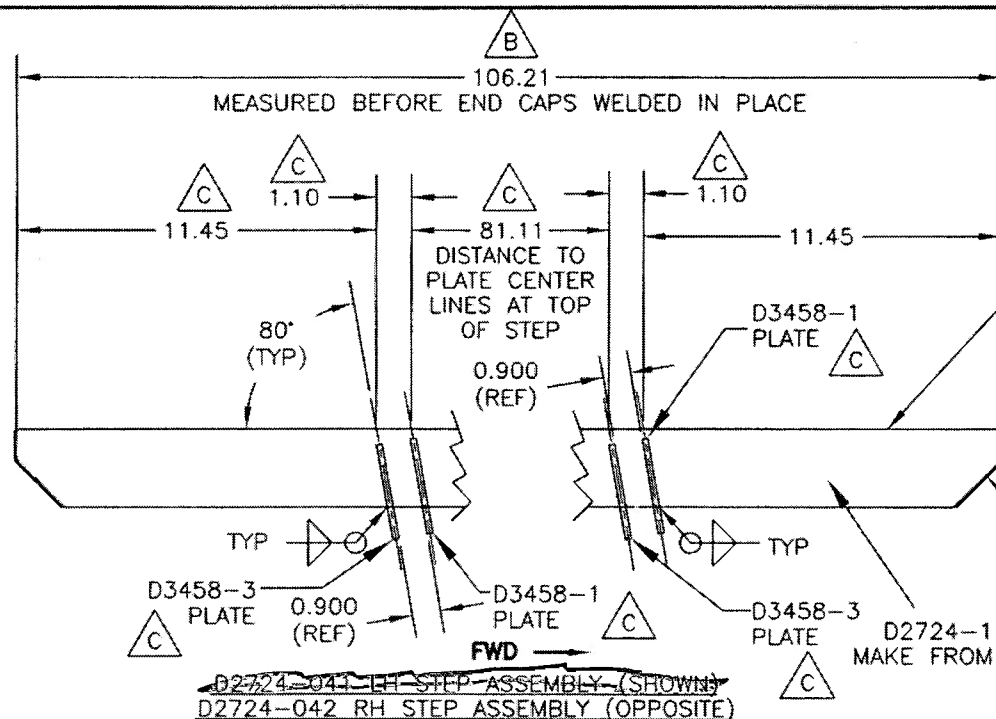
Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



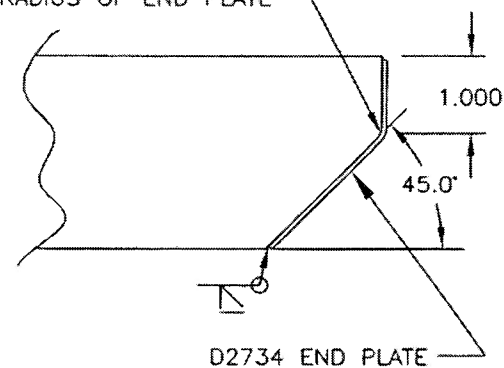
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

~~D2724-041 LH STEP ASSEMBLY (SHOWN)~~
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	REVISION NO.
				206L/407 STEP ASSEMBLY
				NEW ISSUE
				UPDATED WELD DETAIL
				REVISED TOLERANCES
				RE-DESIGN, ADD D3458-1/-3
				SCALE
				NTS
				SHEET 1 OF 1